

Thursday, October 21, 2010 1:01:36 PM

Page 1

Accept

Revision ID:

Item Name: Web, 205 Skidtube

Start Date: 10/21/2010 **Start Qty:** 4.00

Required Date: 10/28/2010 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 10/0-21

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2596	Rev D								
100		0.00							
	Skidtubes						(4)		
Skidtubes	Memo	0.00							
Skidtubes	✓ 1- Cut D2500-3-100 to length: 99.5" ✓ 2- Use Jig DT8093 to drill pilot holes #30 ✓ 3- Open to 0.630" diameter as per Dwg D2596 ✓ 4- Deburr		SAD	10-10-21					
110		0.00							
	Chemical Conversion Coat per QSI005 4.1								
HandFinish	Memo	0.00					(4)		
Hand Finishing			SAD	10-10-21					
120		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00					4		P.O.
Quality Control			SAD	10-10-22					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63114

Thursday, October 21, 2010 1:01:36 PM

Page 2

Item ID: D2596

Accept

Revision ID:

Item Name: Web, 205 Skidtube

Start Date: 10/21/2010 Start Qty: 4.00

Required Date: 10/28/2010 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: CWA

0.00



Packaging

Memo

0.00

SAD

10-10-22

4

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/22 *[Signature]*

ME

10-10-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, October 21, 2010 1:01:39 PM

Page 1

Work Order ID: 63114

Parent Item: D2596

Parent Item Name: Web, 205 Skidtube


Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: D□99.02.02□Changed QA to QC, Added Step 6 and Cost□DM
IPP Rev:E 07-07-09 Incorporated DEO 9183 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-3-100  Ext'n -I' Beam Web 4"		Manufactured	No			100	Each	79.0000	1	4			



SAD 10-10-21

Location

Loc Qty

Loc Code

LG

79

51957

79

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

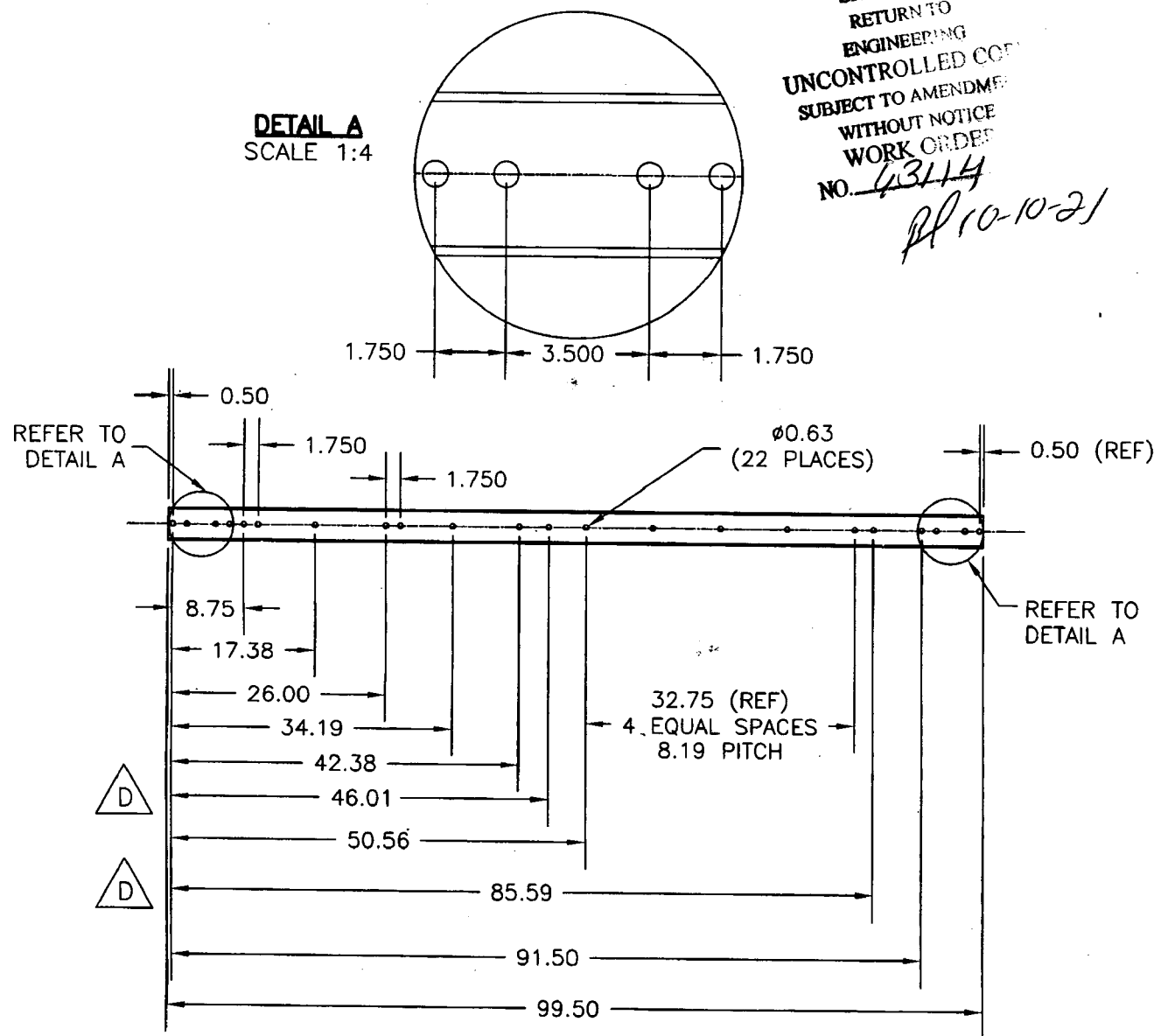
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07-06-68

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RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43114
2

PL 10-10-21

DETAIL A
SCALE 1:4



D2596 WEB

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

DESIGN NO.	84	DRAWING BY	044	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. D
DATE	07.04.17			D2596	SHEET 1 OF 1
				TITLE	SCALE
				205 WEB	1:20
A		96.09.16		NEW ISSUE	
B		97.07.23		Ø0.63 HOLE WAS Ø0.56	
C		98.09.14		INCORPORATED DEO 9097	
D		07.04.17		INCORPORATED DEO 9183	

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